shown in Fig. 6, the sides **16** of the body **17** being coextensive with the sides **18** of the handle **19**.

An alternative form of toothbrush product formed from a similar blank is illustrated in Fig. 5. Thus, where so desired a single or multiple die may be employed to punch out the individual brushes on the dotted lines as shown, rather than cutting completely across the blank B as shown in Fig. 4. In the case of the die punch-out there will, of course, be some waste stock resulting from the die operation. There is, however, more flexibility in the die cut in that the forward ends of the handle and body portion can be cut in a curved line as shown at **20**, and the opposite end of the handle portion may be cut out in a toothpick **21** without further steps in the manufacture of the individual brushes. Here again the die operation may be a consecutive movement with the blank B progressing one space at a time to form the individual toothbrush, or a plurality of the die members may cut out a prescribed number of the toothbrushes in each cutting movement. Where the die is used, the bevel **22** as shown in Figs. 2 and 3 may be formed during the cutting operation. It is understood, of course, that the bevel may be attained by other means such as touching the underside of the handle to a grinding or beveling instrument well known to the art. Since the latter requires a separate operation, it is preferred to accomplish the beveling of the edges in the same operation which cuts the toothbrush from the blank B. Details of the toothpick end **21** are shown in Fig. 9. The pointed end **21** can be formed either by punching as a die cut point or by subsequently shaving down the handle **19** of the individual brush as cut from the blank shown in Fig. 4. An alternative form of surface irregularity on the resilient strip **11** is shown in the brush body **22** of Fig. 8. Here the surface configuration consists in a plurality of points **23** which may individually take on the pyramidal shape as shown. The rest of the brush formation may be accomplished as previously noted. The points **23** will have the advantages of being able to enter crevices between the teeth regardless of the direction of motion employed by the user in brushing his teeth.

Either before or after the cutting of the individual toothbrushes from the prepared blanks B the resilient and absorbent strip **11** is preferably impregnated with a dentifrice. This dentifrice may be in liquid form in order to impregnate the seals or fibers of the brush body **17**, after which the liquid vehicle may be evaporated so as to leave the body **17** in a dry or almost dry condition. Although dentifrice may be applied to the brush at the time of using, it is preferred to preliminarily impregnate the body so as to form an entirely self-contained toothbrush, ready for use without any other preparation on the part of the user. The toothbrush after formation may be sealed in a sanitary condition within a sack or container **24** as shown in Fig. 1. In some instances, I may cut blocks of individual toothbrushes at spaced intervals along the blank B and merely score or partially cut between the individual brushes comprising each block. In such case, the user will purchase a block of individual brushes and will break off along the scored line each individual brush at the time of use.

My brushes may be dispensed in drug stores, hotel lobbies, transportation depots, vehicles such as airplanes or trains, hospitals, and in countless other private and public places, either by clerks or through mechanical dispensing equipment. When a purchaser desires to use the brush, he merely removes the sanitary container **24**, wets the body of the brush with a few drops of water and then proceeds to clean his teeth in the ordinary manner. Immediately after usage, he disposes of the brush and will take a new one when he again desires to clean his teeth.

It will, of course, be understood that various changes may be made in the form, details, arrangement and proportions of the parts without departing from the scope of my invention.

What I claim is:

1. A method for making a plurality of disposable sanitary toothbrushes from a sheet of relatively stiff and thin material and an elongated relatively narrow strip of resilient and absorbent material which consists in, bringing the strip into engagement with one surface of the sheet marginally thereof, sealing the engaging surfaces between the strip and sheet surface, cutting at longitudinally spaced narrow intervals transversely through the strip and at the same time partially into the exposed surface of said sheet across the width thereof to produce easily severable lines.

2. A method for making a plurality of disposable sanitary toothbrushes from a sheet of relatively thin and stiff material and an elongated relatively narrow strip of resilient and absorbent material which consists in, bringing the strip into engagement with one surface of the sheet marginally thereof, sealing the engaging surfaces between the strip and sheet surface, cutting transversely in a plurality of narrowly spaced parallel cuts through the strip and at the same time continuing to cut into the exposed surface of the sheet across the full width thereof in score lines forming straightly aligned continuations of the respective spaced parallel cuts.

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